

Work Order ID 51440

August 24, 2009 1:19:14 PM



Page 1

Item ID: D2037-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm

Start Date: 8/25/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SB 09/08/25

10 0

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037
ends of D2037-101 tube as required using DT8545
3-Deburr as required

2-Flatten

7m-h 09/08/25 (10X)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> 5 09/08/25

(10X)

Work Order ID 51440



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Item ID: D2037-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm

Start Date: 8/25/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00

SAP 09-08-25



Packaging

Memo

0.00



Packaging

140

QC21- Final Inspection - Work Order Release

0.00

09/08/26 *[Signature]*



QC

Memo

0.00

Quality Control

BP *09-8-26*

Picklist Print

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Page 1

Work Order ID: 51440

Parent Item: D2037-101RevD

Parent Item Name: Arm

Comments:

Start Date: 8/25/09

Required Date: 8/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			110	f	262.0510	41.2211			



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

262.0510026

107518

7.27

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

111619

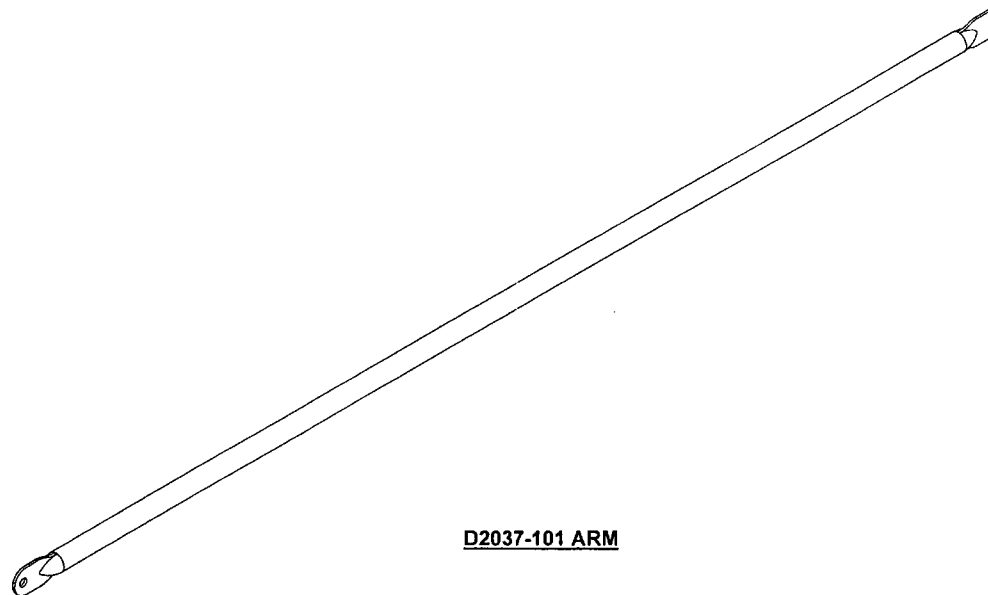
13.2700026

112187

211.821

43

8/25/08/25



D2037-101 ARM

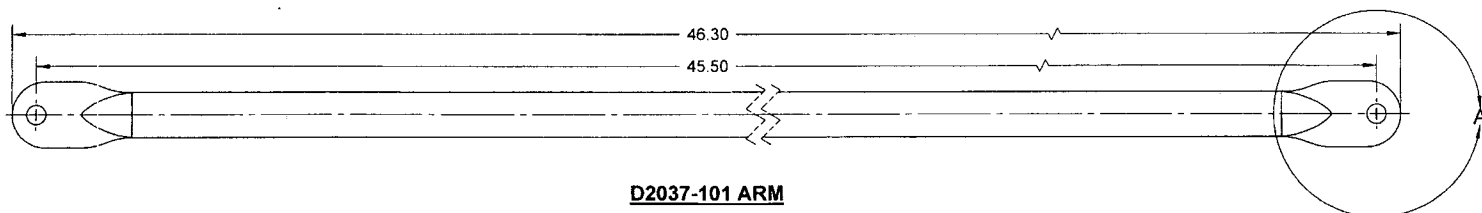
W/O
51440

REL
08.07.07

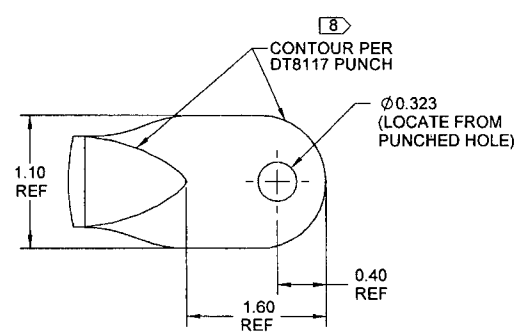
NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, $\phi 0.750 \times 0.049$ WALL.
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

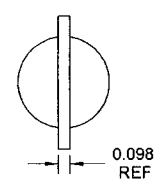
D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.05.08	<small>COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2037-101 ARM



DETAIL A
SCALE 2X
2 PL



51440

RELEASED
06-07-07 WAD

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	5	DRAWING NO.	REV. D
MFG. APPR.	WAD	D2037	SHEET 2 OF 2
APPROVED	WAD	TITLE	SCALE
DE APPR.	WAD	ARM	NTS
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